Work Order ID 101856 Page 1 May-15-13 1:50:54 PM Item ID: D2182B050 Accept *N900040100* Setup Start Revision ID: Item Name: Clamp Cushion Black **Start Date:** 5/15/13 **Start Qty: 30.00** *30* **Cust Item ID:** Required Date: 5/22/13 Req'd Qty: 30.00 **Customer:** Reference: Run Process Plan: MLJ Date: B-S-15 Tooling: **Approvals:** Date: Stop QC: _____ Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Description Work Center ID **Run Hours** Code Qty Qty Number Stamp **Revision Nbr Draw Nbr** D2182 Rev C 100 0.00 Packaging *100* Packaging 0.00 Memo Packaging Cut as per dwg 110 QC6- Inspect dimensions to drawing *110* 21.20 no.0 QC Memo Quality Control

120

Identify as per dwg & Stock Location:

120

Packaging

Packaging

Memo

0.00

										DQA:	Date	e:
NCR: Y	res / No				WORK ORDER NON-O	100	NFOR	MANCE / UP	DATE		Date	
							i .			QA Closed:	Date	2.
Work Orde	or.				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	No				Rework Scrap Use-as-is Work Order Update		1	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
WCK I			 · · · - ·		Work Order opdate	ل		20.80.00		J		
Root				Descri	ption of work order update	Π	Initial	Act	tion	Sign &		
Cause	Date	Step	Qty	,	or Non-conformance	Ch	nief Eng	Desci	ription	Date	Verification	QC Inspector
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	Bending			-	Bend	\vdash	Grain		<u> </u>	Ovalized	-	Pressure/Forced
	\vdash	Not Conce	ntric to	o/s	BOM/Route	\vdash	Hardwa			Over/Under		Temperature/Cure
	Cracks			<u> </u>	Broken/Damaged	 	4	ion Incomplete	_	Part Incorre	<u> </u>	Weld
	Crushed/Crimped				Burrs	\vdash	-	tions Incomplete/I	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs			<u> </u>	Contamination	<u> </u>	Mainte		<u> </u>	Part Moved		
	Heat Tre			<u> </u>	Countersink	<u></u>	Mislabe		<u> </u>	Positioned V		٦
		on Strip ir	1 Tube	_	Cut Too Short	<u> </u>	Misrea	d	L	Power Loss/	Surge	Other
	Ripples		•		Drill Holes	_	Offset					
	—	Waves in		n L	Drawing	Ŀ	4	Calibration			· · · · · · · · · · · · · · · · · · ·	
	Turning Sequence Finish						Out of	Sequence				

Outside Dimensions

Wave/Twist in Tube

Folio -

May-15-13 1:50:54 PM

Item ID: D2182B050

Accept

N900040100

Date:

Date:

Setup Start

Revision ID: Item Name:

Clamp Cushion Black

Start Date: 5/15/13 Required Date: 5/22/13 **Start Qty: 30.00** Req'd Qty: 30.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: Date: Tooling:

Start

Stop

Sequence ID/

Operation Description Set Up/

SPC (Y/N):

Tool ID

Tool # Plan Code Qty

Reject Accept **Qty**

Run

Reject Insp. Number Stamp

Work Center ID 130

QC21- Final Inspection - Work Order Release

Run Hours

0.00

130

OC Quality Control

Date:

Memo

0.00

										DQA:	Date	•
NCR: Y	es / No				WORK ORDER NON-C	ON	NFOR	MANCE / UP	DATE	QA Closed:	Date	:
Work Orde					DISPOSITION				AGAINST DE			
Part N NCR N	lo				Rework Scrap Use-as-is Work Order Update	Machining Small Fall Thermoforming Finishing			Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	1	nitial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
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	Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa		_	Over/Under	<u></u>	Temperature/Cure
	Cracks				Broken/Damaged	-	1	ion Incomplete		Part Incorred	⊢	Weld
	Crushed/	'Crimped			Burrs		1	ions Incomplete/	'Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	$oxed{oxed}$	Mainte			Part Moved		
	Heat Trea	at			Countersink		Mislabe	eled		Positioned V	_	7
	Inspectio	n Strip in	Tube		Cut Too Short		Misread	t		Power Loss/	Surge	Other
[Ripples in	n Bend]	Drill Holes		Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

May-15-13 1:50:57 PM

Work Order ID: 101856

D2182B050 Parent Item:

Parent Item Name: Clamp Cushion Black

101856

D2182B050

Start Date: 5/15/13

Required Date: 5/22/13

Page 1

Start Qty: 30.00

Required Qty: 30.00

Comments:

IPP: B 99.03.02 Re-format

per revC DD verf:EC

DM IPP Rev:C 10.11.02 as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2182B		Manufactured	No			100	f	26.0613	0.4166	12.498			
D2182B									**	12.470	12/5	-1,00	~ ()

Rubber Cushion

Location

ST412

93429

Loc Qty 26.06134

Loc Code

26.06134

								1				DQA:	Da	te:	
NCR:	⁄es	/ No				WORK ORDER NON-O	CON	IFOR	MANCE / UP	DATE		·			
								:				QA Closed:	Da	te:	
Work Orde						DISPOSITION				AGAINST	DE	PARTMENT	PROCESS		
	-					Rework Scrap	Crosstube Small Fab					Engineering Quality			
Part N	NO	.				Use-as-is	┨		Machining noforming	Finishing		4	e/Packaging	$\overline{}$	Other
NCR No.						Work Order Update Large Fab Composite						Supplier			
Root					Descri	ption of work order update	lı	nitial	Ac	tion	******	Sign &			
Cause		Date	Step	Qty	1	or Non-conformance	Chi	ief Eng	Desc	ription		Date	Verificatio	n	QC Inspector
Doc/Data						· · · · · · · · · · · · · · · · · · ·		1							}
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Unapproved							<u> </u>		<u> </u>						<u> </u>
	FAULT CATEGORY														
Landi	ng (Gear				General	_			•		_		_	-
		Bending				Bend	\square	Grain	•		_	Ovalized		L	Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	are		Ľ	Over/Under	tolerance	oxdot	Temperature/Cure
	Cracks					Broken/Damaged		Inspection Incomplete				Part Incorrect			Weld

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread Offset Wrong Stock Pulled

Other

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination

Countersink

Cut Too Short

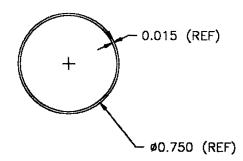
Drill Holes

Drawing

Finish

Folio

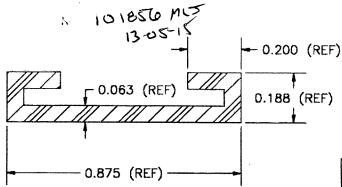
RELEASEDS



D2182-050, HEAT SHRINK LENGTH

> EG: 3.5 LONG: D2182-035 10 LONG: D2182-100

MATERIAL: RAYCHEM RNF-100-3/4-CL HEAT SHRINKABLE INSULATION SLEEVING



UNCU SUIC 1

W-WHITE B-BLACK D2182W050, RUBBER CUSHION LENGTH

> EG: WHITE 3.5 LONG: D2182W035 BLACK 10 LONG: D2182B100

MATERIAL: SANTOPRENE 101-73 CONFORMS TO MIL-R-3065





							:			DQA:	Date	2:			
NCR: Ye	es / No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE	QA Closed:	Date	;			
,					DISPOSITION				AGAINST DE						
Work Order	:				DISPOSITION	_			AGAINSI DE	.PARTIVILITI	, r NOCE33				
Part No	0				Rework Scrap Use-as-is	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing			-1	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other				
NCR No	0			 	Work Order Update			Large Fab	Finishing Composite	, Rec/Stol	Supplier	- Other			
Root				Descri	ption of work order update		Initial	Ac	tion	Sign &					
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Eng Description		Date	Verification	QC Inspector			
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					BOM/Route Broken/Damaged	\vdash	Hardwa	on Incomplete	· -	Part Incorre	├	Weld			
}	⊣ ⊢				₹	\vdash	-{ ` `	ions Incomplete/	Unclear	Part Lost/Mi	—	Wrong Stock Pulled			
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F	Wave/Twist in Tube Folio						Outside Dimensions								